












Date: Thursday, 18/09/2008 11:12:59 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : RADIUS BLOCK
<b>Job Number</b> : 42099	
<b>Estimate Number</b> : 10822	
<b>P.O. Number</b> :	<b>Part Number</b> : D2274
<b>This Issue</b> : 18/09/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2274 REV F
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : F
<b>Previous Run</b> : 41422	<b>Material</b> : 499
<b>Written By</b> :	<b>Due Date</b> : 15/10/2008 <b>Qty:</b> 500 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : JUD 08.9.18	
<b>Comment</b> : Est. H 00.05.18 Added inspection level 8 EC	
<b>Additional Product</b>	
Job Number: 	
<b>Seq. #:</b>	<b>Machine Or Operation:</b>
<b>Description :</b>	
1.0	M6061T6B0750X00125 6061-T6 Bar .750 x .125
	
	
<b>Comment:</b> Qty.: 0.0962 f(s)/Unit Total: 48.0900 f(s) 6061-T6 Bar .75" x .125" Material: 6061-T6 (QQ-A-250/11) or 5052-H34 (QQ-A-250/8) 1/8" X 3/4" BarBatch _____ M103503 X 144 + 63 M104480 X 144 + 27 M103755 X 126 (10 feet of M103503 has not been taken from computer, please enter manually from office)	
2.0	SHEAR SHEAR
	
	
<b>Comment:</b> SHEAR Shear blanks 9.00" long +/- 0.030" Note: 1 blank makes 9 pieces N.A 08/09/27	
3.0	HAAS1 HAAS CNC VERTICAL MACHINING #1
	
	
<b>Comment:</b> HAAS CNC VERTICAL MACHINING #1 Machine as per folio D2274 N.A 08/09/27	
4.0	QC2 INSPECT PARTS AS THEY COME OFF MACHINE
	
	
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE N.A 08/09/27 499	
5.0	QC8 SECOND CHECK
	
	
<b>Comment:</b> SECOND CHECK DIP 08/09/29 08/09/29 499	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RADIUS BLOCK

Job Number: 42099

Part Number: D2274

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble

Deburr any rough edges after tumbling

08/10/18 499 Hm

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MF

08/11/10

499

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-11-10

x499

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

St 24

MF

08/11/12 x499

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/12

Job Completion



MF 08-11-12

H:\FORMS\

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

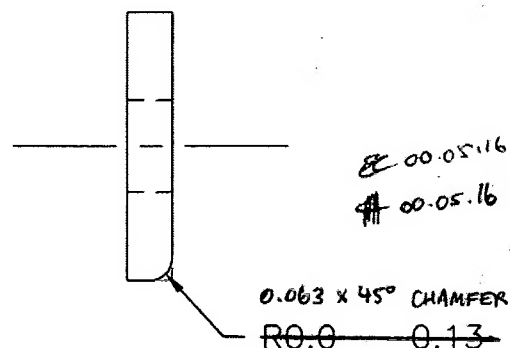
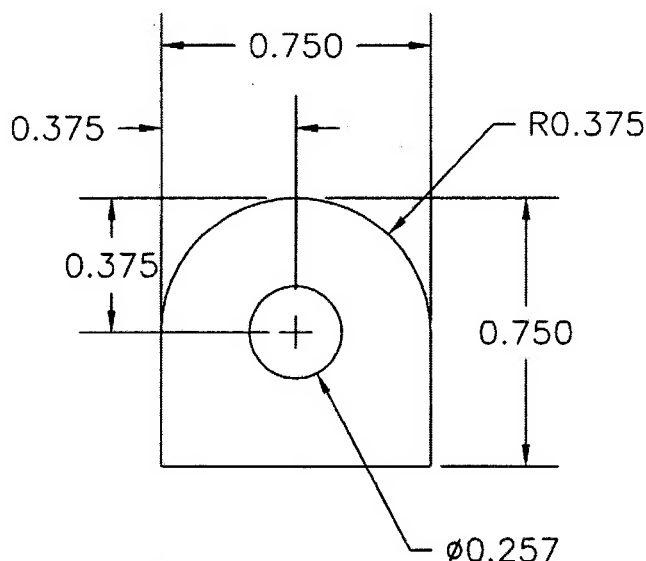
NOTE: Date & initial all entries





DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2274	REV. F SHEET 1 OF 1
DATE 98.08.11		TITLE RADIUS BLOCK	SCALE 2:1
A	94.09.29	NEW ISSUE	
C	95.07.12	RADIUS ENDS	
D	97.03.24	ADD MATERIAL SPECIFICATION	
E	97.12.12	ADD FINISH & TOLERANCE QSI	
F	98.08.11	R0.0 - 0.13 WAS R0.063 - 0.125	

**RELEASED**  
98/08/18 KE



MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK  
OR 6061-T6 (QQ-A-250/11) 0.125 THICK

FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 42099